

Work Order ID 85098

85098

Page 1

June-01-12 3:43:43 PM

Item ID: D3405-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug Assembly

Start Date: 01/06/2012 Start Qty: 24.00

24

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/04

Tooling:

Date:

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3405	Rev B
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100		0.00							
-----	--	------	--	--	--	--	--	--	--

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

304 . 125

IB12-6-7

110		0.00							
-----	--	------	--	--	--	--	--	--	--

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

IB12-6-7

120		0.00							
-----	--	------	--	--	--	--	--	--	--

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

30

W12.06.07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: Date: Tooling: Date: QC: Date: SPC (Y/N): Date:

Run Start *NR1* Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE					30			12/06/11
Brake NC	Memo	0.00							
Brake NC	1-Deburr 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld as per Dwg D3405 use DT8484 Identify as D3405-041								

5/12/06/12

Conte
x30

30

12-7-18

W/O:		WORK ORDER CHANGES					
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N9000040100

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24

Cust Item ID:

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24

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

0.00

Quality Control

30x 12.7.18

DAS
24
9-89

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

DAS
16
9-89

12/6/19

count

30

180

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

180

Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:30
400 OF
8:00

30x

MT
12/07/19

W121841

Dart Aerospace Ltd

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Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

30 12-7-19

200

Identify as per dwg & Stock Location: SI 478 0.00

200

Packaging

Memo

0.00

Packaging

30x 12-7-19

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/7/23 ME 12-07-20

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

June-01-12 3:43:47 PM

Page 1

Work Order ID: 85098

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Parent Item: D3405-041

D3405-041

Parent Item Name: Lug Assembly

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP A05.09.01New issueKJ/JLM
IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3404-1		Manufactured	No			100	Each	43.0000	1	24			
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D3404-1

GHW Lug

**

EL 12-7-17

85/100 x 30

Location

Loc Qty

Loc Code

WA

43

83879

43

M304S11GA

Purchased

No

150

sf

116.8900

0.154

3.890526

5,

M304S11GA

304/316 0.125 Sheet

**

Bk-6-7

Location

Loc Qty

Loc Code

MAT020

116.89

121380

29.9

121780

86.99

12180

(30)

Dart Aerospace Ltd

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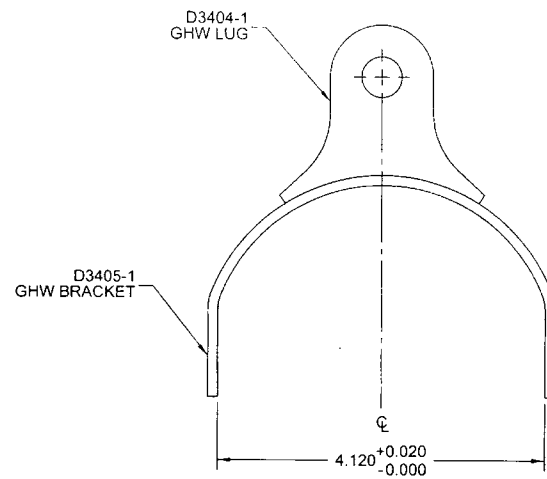
W/O:		WORK ORDER CHANGES					
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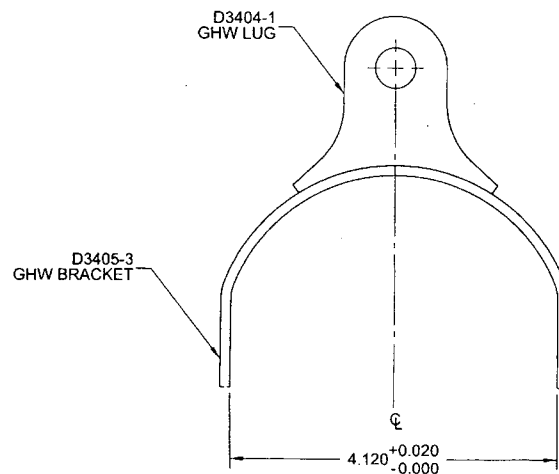
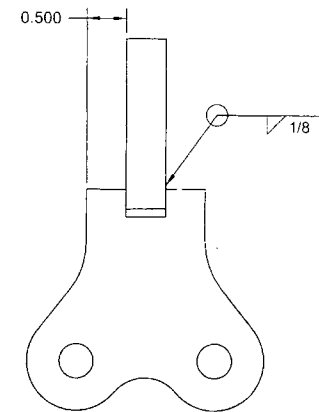
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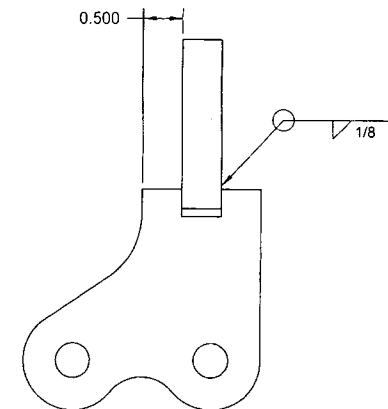
NOTE: Date & initial all entries



D3405-041 LUG ASSEMBLY



D3405-043 LUG ASSEMBLY



RELEASED
06/12/18

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

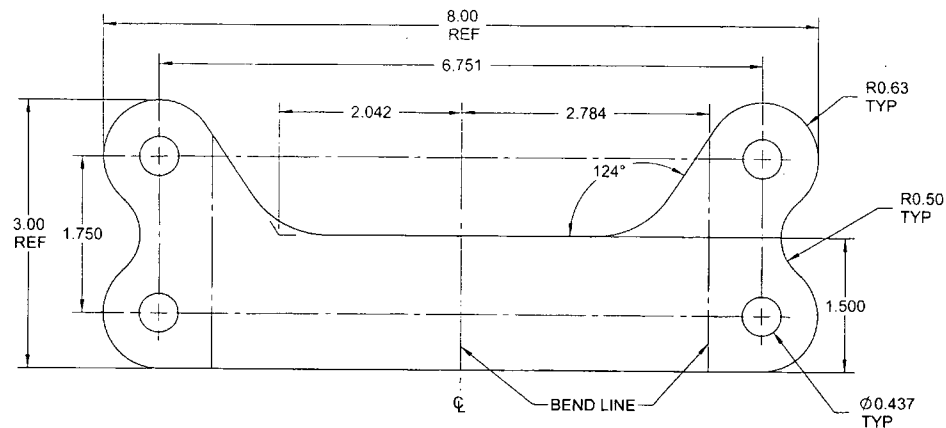
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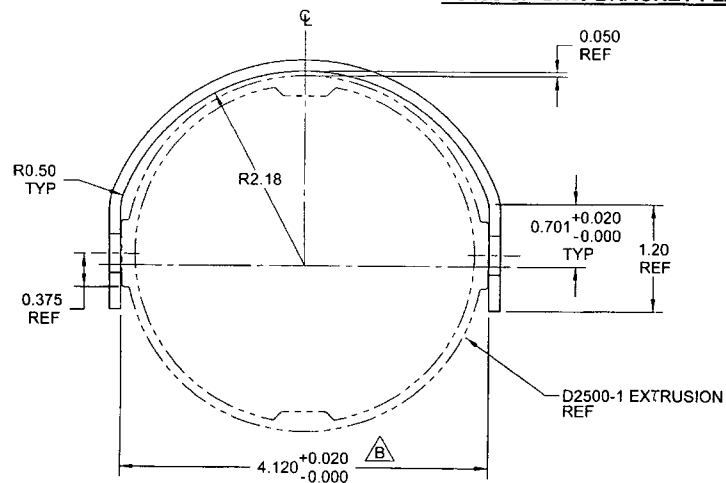
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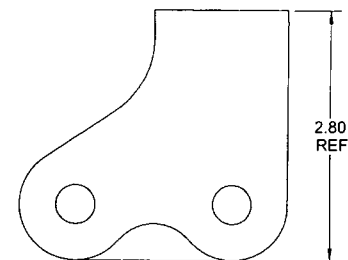
NOTE: Date & initial all entries



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
08/12/18

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